

# Work Order ID 133594

**\*133594\***

Page 1

Thursday, June 11, 2015 10:17:00 AM

Item ID: D3369-5 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Spacer  
 Start Date: 6/11/2015 Start Qty: 50.00 **\*50\*** Cust Item ID:  
 Required Date: 6/11/2015 Req'd Qty: 50.00 **\*50\*** Customer:  
 Reference:

Approvals: Process Plan: MLS Date: JUN 11 2015 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr                       | Revision Nbr             |                      |         |        |              |               |               |                  |                |
| D3369                          | B                        |                      |         |        |              |               |               |                  |                |

100 0.00  
**\*100\*** 30 0 Jm15-6-16  
 Waterjet  
 FLOW CNC Waterjet  
 304.100"  
 Memo  
 1- Cut as per dwg  
 Prog rev: B  
 Dwg rev: B  
 2- Deburr

110 0.00  
**\*110\*** 50 0 Jm15-6-16  
 QC  
 Quality Control  
 Memo

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**\*133594\***

Page 2

Item ID: D3369-5 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Spacer  
 Start Date: 6/11/2015 Start Qty: 50.00 **\*50\*** Cust Item ID:  
 Required Date: 6/11/2015 Req'd Qty: 50.00 **\*50\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                           | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp                          |
|--------------------------------|----------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|-----------------------------------------|
| 120                            | QC8- Inspect parts - second check                  | 0.00                 |         |        |              |               |               |                  |                                         |
| <b>*120*</b>                   |                                                    |                      |         |        |              |               |               |                  |                                         |
| QC                             | Memo                                               | 0.00                 |         |        |              |               |               |                  |                                         |
| Quality Control                |                                                    |                      |         |        |              |               |               |                  | DAS<br>38<br>9-89<br>JUN 16 2015        |
| 150                            | Identify as per dwg & Stock Location: <u>S/OSS</u> | 0.00                 |         |        |              |               |               |                  |                                         |
| <b>*150*</b>                   |                                                    |                      |         |        |              |               |               |                  |                                         |
| Packaging                      | Memo                                               | 0.00                 |         |        |              |               |               |                  |                                         |
| Packaging                      |                                                    |                      |         |        |              |               |               |                  | S/O<br>DAS<br>27<br>9-89<br>JUN 16 2015 |
| 160                            | QC21- Final Inspection - Work Order Release        | 0.00                 |         |        |              |               |               |                  |                                         |
| <b>*160*</b>                   |                                                    |                      |         |        |              |               |               |                  |                                         |
| QC                             | Memo                                               | 0.00                 |         |        |              |               |               |                  |                                         |
| Quality Control                |                                                    |                      |         |        |              |               |               |                  | ML5 JUN 17 2015                         |

U 15.06.17

# Picklist Print

Thursday, June 11, 2015 10:17:04 AM

Page 1

Work Order ID: 133594

**\*133594\***

Parent Item: D3369-5

**\*D3369-5\***

Parent Item Name: Spacer

Start Date: 6/11/2015

Required Date: 6/11/2015

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP REV:B 13.04.23 PER DWG REV.B DD VERF:JLM

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M304S12GA

Purchased

No

sf

75.2313

①

**\*M304S12GA\***

\*\*

Jm15-6-16.

304/316 0.100" Sheet

Location

Loc Qty

Loc Code

MAT019

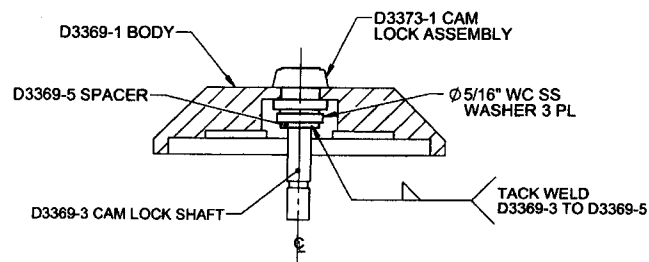
75.2313

m131322

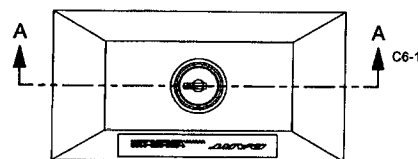
75.2313

131322





**SECTION A-A B6-1**



**D3369-041 BATTERY LOCK ASSEMBLY**

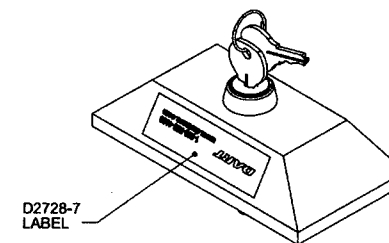
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs
- 8) WELD PER DART QSI 004

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 133594 MJS

1506-11

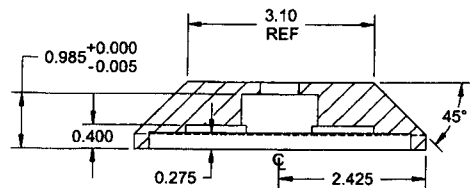
| ITEM | QTY<br>-041 | P/N       | DESCRIPTION           |
|------|-------------|-----------|-----------------------|
|      | X           | D3369-041 | BATTERY LOCK ASSEMBLY |
| 1    | 1           | D2728-7   | LABEL                 |
| 2    | 1           | D3369-1   | BODY                  |
| 3    | 1           | D3369-3   | CAM LOCK SHAFT        |
| 4    | 1           | D3369-5   | SPACER                |
| 5    | 1           | D3373-1   | CAM LOCK ASSEMBLY     |
| 6    | 1           | 5/16 WC   | SS FLAT WASHER        |



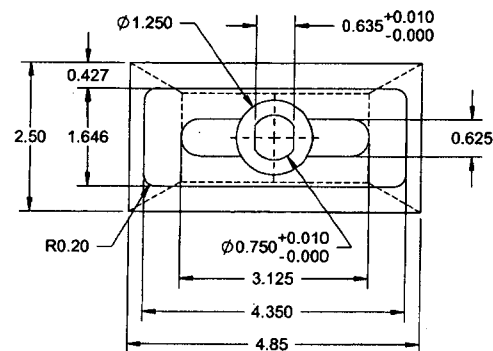
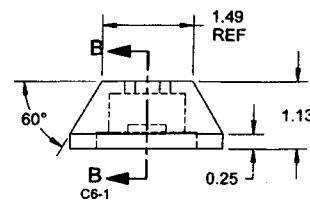
**D3369-041 BATTERY LOCK SHOWN LOCKED WITH KEY**

RELEASED  
2013-04-22  
WP

| B          | UPDATE MATERIAL FOR D3369-1/3/5 AND DRAWING FORMAT (REF CIR13-16) | SFM                                                                                                                                                                                                                                                                                                                                                                                                               | 13.04.05 |
|------------|-------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|
| A1         | ADD TACK WELD 0.865 WAS 0.925                                     | RF                                                                                                                                                                                                                                                                                                                                                                                                                | 05.02.11 |
| A          | NEW ISSUE                                                         | MB                                                                                                                                                                                                                                                                                                                                                                                                                | 04.12.06 |
| REV.       | DESCRIPTION                                                       | BY                                                                                                                                                                                                                                                                                                                                                                                                                | DATE     |
| DESIGN     | MB                                                                | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA<br><br>DRAWING NO. <b>D3369</b><br>TITLE <b>BATTERY LOCK</b><br><small>COPYRIGHT © 2004 BY DART AEROSPACE LTD<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |          |
| DRAWN      | SFM                                                               |                                                                                                                                                                                                                                                                                                                                                                                                                   |          |
| CHECKED    | MA                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                   |          |
| MFG. APPR. | MA                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                   |          |
| APPROVED   | MA                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                   |          |
| DE APPR.   | MA                                                                | REV. B<br>SHEET 1 OF 4<br>SCALE<br>NTS                                                                                                                                                                                                                                                                                                                                                                            |          |
| DATE       | 13.04.05                                                          |                                                                                                                                                                                                                                                                                                                                                                                                                   |          |



**SECTION B-B C4-1**



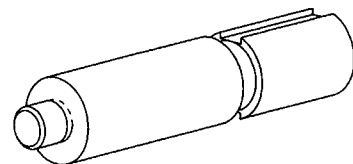
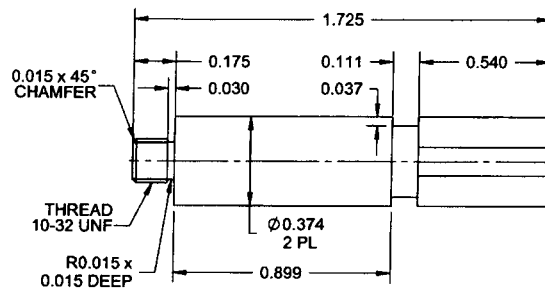
**D3369-1 BODY**

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)   
OR QQ-A200/8 OR AMS-QQ-A220/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

**RELEASED**  
2013-04-22  
*WMD*

|            |          |                                                                                                                                                                                                                                                                                     |              |
|------------|----------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | MP       | <b>DART AEROSPACE LTD</b>                                                                                                                                                                                                                                                           |              |
| DRAWN      | SPH      | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                                         |              |
| CHECKED    |          | DRAWING NO.                                                                                                                                                                                                                                                                         | REV. B       |
| MFG. APPR. |          | D3369                                                                                                                                                                                                                                                                               | SHEET 2 OF 4 |
| APPROVED   |          | TITLE                                                                                                                                                                                                                                                                               | SCALE        |
| DE APPR.   | N/A      | BATTERY LOCK                                                                                                                                                                                                                                                                        | NTS          |
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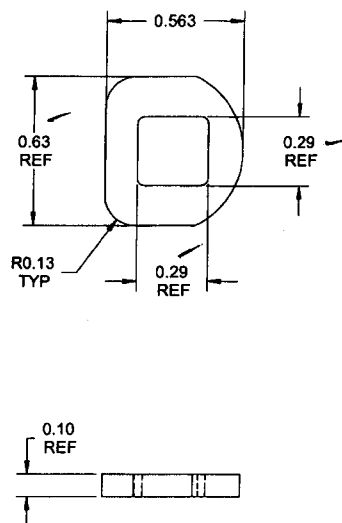
**D3369-3 CAM LOCK SHAFT**

**NOTES:**

- 1) MATERIAL: AISI 303 SS ROUND BAR PER ASTM A582  
REF DART SPEC M303 R0.375
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01 lbs

**RELEASE**  
2013-04-22

|            |          |                                                                                                                                                                                                                                                                                                  |              |
|------------|----------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | MB       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                         |              |
| DRAWN      | SFM      |                                                                                                                                                                                                                                                                                                  |              |
| CHECKED    |          | DRAWING NO.                                                                                                                                                                                                                                                                                      | REV. B       |
| MFG. APPR. |          | D3369                                                                                                                                                                                                                                                                                            | SHEET 3 OF 4 |
| APPROVED   |          | TITLE                                                                                                                                                                                                                                                                                            | SCALE        |
| DE APPR.   | N/A      | BATTERY LOCK                                                                                                                                                                                                                                                                                     | NTS          |
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**D3369-5 SPACER**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, ANNEALED, 0.109 THICK (12 GAUGE)  
PER ML-S-5059 OR AMS 5513/5524 (304/316) OR ASTM A240 OR ASME SA240
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: LESS THAN 0.01 lbs



**RELEASED**  
2013-04-22

|            |          |                                                                                                                                                                                                                                                                                                  |              |
|------------|----------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | MB       | <b>DART AEROSPACE LTD</b>                                                                                                                                                                                                                                                                        |              |
| DRAWN      | SFM      | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                                                      |              |
| CHECKED    |          | DRAWING NO.                                                                                                                                                                                                                                                                                      | REV. B       |
| MFG. APPR. |          | D3369                                                                                                                                                                                                                                                                                            | SHEET 4 OF 4 |
| APPROVED   |          | TITLE                                                                                                                                                                                                                                                                                            | SCALE        |
| DE APPR.   | N/A      | BATTERY LOCK                                                                                                                                                                                                                                                                                     | NTS          |
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